

Work Order ID 105680

\*105680\*

Page 1

Monday, August 12, 2013 10:54:08 AM

Item ID: D3537-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 8/12/2013 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals: Process Plan:

Date: 13/08/12 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: Prog Rev: 2-Debur

P/O: 20895

CL 13/08/12 100

Purch's

water jet / machine as per dwg D3537 REV.C

110

QC2- Inspect parts off machine FAI/FAIB

0.00 Springside Industries

\*110\*

QC

Memo

0.00

Quality Control

rec'd.

rec'd + inspect attached c/c to w/o

13/8/12 (100)

120

QC3- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

27  
13917

100

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Page 2

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\*N9000040100\*

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Revision ID:

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Item Name: Wearpad

Start Date: 8/12/2013 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

\*130\*

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-  
Identify as D3537-1

100

SB 13/09/17

140

0.00

\*140\*

Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat  
126588 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any  
weld that penetrated through Wearpad if necessary

(42) Q/mf/mal 17-9-23

150

QC10- Inspect visual per QSI004- ground welds

0.00

\*150\*

QC

Memo

0.00

Quality Control

(42) 1309-23

DA 09 89

# Work Order ID 105680

\*105680\*

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Monday, August 12, 2013 10:54:08 AM

Item ID: D3537-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearpad  
 Start Date: 8/12/2013 Start Qty: 100.00 \*100\* Cust Item ID:  
 Required Date: 9/6/2013 Req'd Qty: 100.00 \*100\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|                 |                                               |      |  |  |  |  |  |  |  |
|-----------------|-----------------------------------------------|------|--|--|--|--|--|--|--|
| 160             | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |  |  |  |  |
| *160*           |                                               |      |  |  |  |  |  |  |  |
| QC              | Memo                                          | 0.00 |  |  |  |  |  |  |  |
| Quality Control |                                               |      |  |  |  |  |  |  |  |

|                |                                          |      |  |  |  |  |  |  |  |
|----------------|------------------------------------------|------|--|--|--|--|--|--|--|
| 170            | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 |  |  |  |  |  |  |  |
| *170*          |                                          |      |  |  |  |  |  |  |  |
| Powdercoat     | Memo                                     | 0.00 |  |  |  |  |  |  |  |
| Powder Coating |                                          |      |  |  |  |  |  |  |  |

|                 |                          |      |  |  |  |  |  |  |  |
|-----------------|--------------------------|------|--|--|--|--|--|--|--|
| 180             | QC3- Inspect Part Finish | 0.00 |  |  |  |  |  |  |  |
| *180*           |                          |      |  |  |  |  |  |  |  |
| QC              | Memo                     | 0.00 |  |  |  |  |  |  |  |
| Quality Control |                          |      |  |  |  |  |  |  |  |

mi21279

START TIME: 2:45 FINISH TIME: 3:15 OVEN TEMPERATURE:

42X m/f 13/09/24

42 φ 13 9-25



# Work Order ID 105680

Monday, August 12, 2013 10:54:08 AM

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearpad

Start Date: 8/12/2013 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: FP-600 0.00

\*190\*

Packaging

Memo

0.00

Packaging

190 & all 13/09/27

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

190 / 13/09/27

13-09-27

# Picklist Print

Monday, August 12, 2013 10:54:07 AM

Page 1

Work Order ID: 105680  
Parent Item: D3537-1  
Parent Item Name: Wearpad

Start Date: 8/12/2013 Required Date: 9/6/2013  
Start Qty: 100.00 Required Qty: 100.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

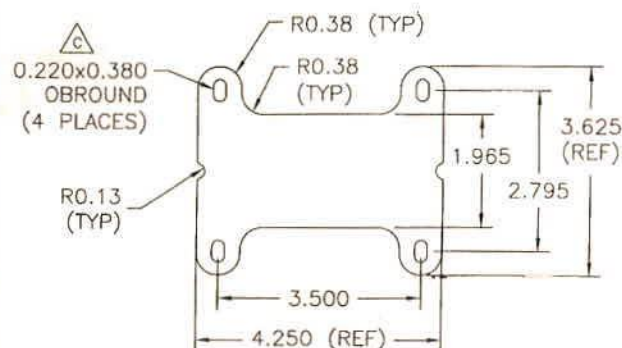
| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA<br>304/316 Sheet .063 |                        | Purchased     | No          |                     |                  | 100             | sf                 | 286.3522       | 0.106       | 11.157895    |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|                                 |                        |               |             | MAT020              |                  | 286.3521686     |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 122245              |                  | 0.1713688       |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 123136              |                  | 140.8           |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 124428              |                  | 23.61           |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 125599              |                  | 5.410631        |                    |                |             |              |               |                |        |
|                                 |                        |               |             | M126159             |                  | 116.360169      |                    |                |             |              |               |                |        |

D3537-1P

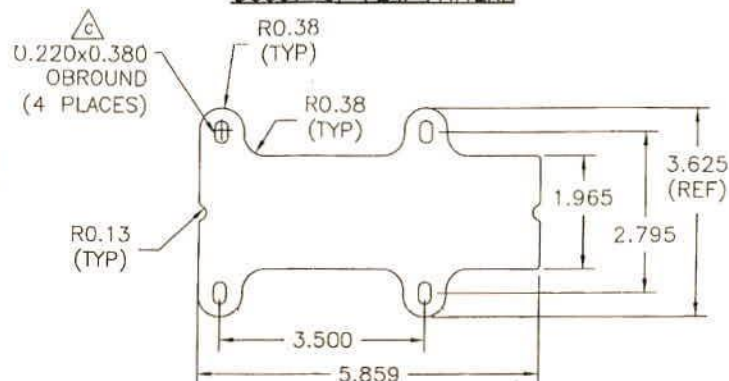
X 100

8/13/12 (100)

### D3537-1F FLAT PATTERN

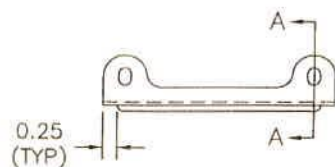


### D3537-3F FLAT PATTERN

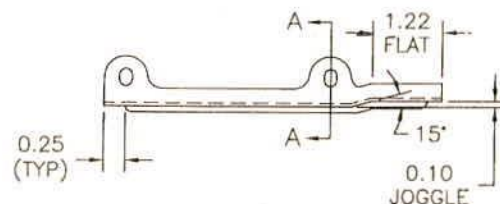


CL 13/08/12  
W10.105680

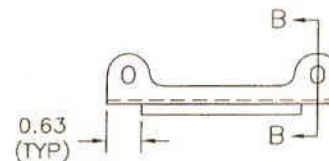
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



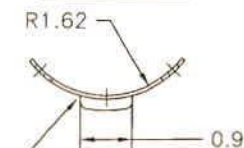
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

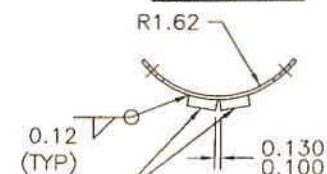
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

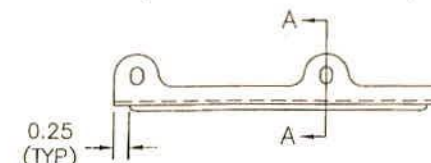
### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

RELEASED  
02.05.08 AH  
per EGN 962

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

|             |          |                                  |
|-------------|----------|----------------------------------|
| C           | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B           | 07.03.20 | ADD AMS 5513 AND AMS 5524        |
| A           | 06.11.06 | NEW ISSUE                        |
| DESIGN      | CB       | DRAWN BY PH                      |
| CHECKED     | #        | APPROVED #                       |
| DATE        | 07.04.13 | TITLE WEARPAD                    |
| DRAWING NO. | D3537    | REV. C                           |
|             |          | SHEET 1 OF 1                     |
|             |          | SCALE                            |
|             |          | 1:2                              |

UNDER REVIEW  
11/12/12  
Fusheng Chang

OK 8/11/15





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO20895**

Purchase Order Date 8/12/2013

PO Print Date 8/27/2013

Page Number 1 of 2

**Order From :**

SPRINGSIDE INDUSTRIES INC.  
673012 ROAD 67A  
R.R. # 1 BADJEROS  
ONTARIO, NOC 1AO  
CANADA

VC-SII001

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

*REVISED*

**Contact Name**

**Vendor Phone**

cell1-226-755-3484

**Ship To Contact**

**Ship To Phone**

**Ship Via:**

FedEx PI collect

**Ship Acct:**

**Buyer**

**Customer POID**

**Customer Tax #**

**Terms**

**Currency**

**FOB**

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

**FAXED**  
(613) 632 1053

| Line Nbr | Reference Vendor Part Number<br>Line Comments<br>Delivery Comments | Description/<br>Mfg ID | Req Date/<br>Taxable<br>Promise Date | CD | Req Qty/<br>Unit of<br>Measure | PO Unit Price      | Extended Price |
|----------|--------------------------------------------------------------------|------------------------|--------------------------------------|----|--------------------------------|--------------------|----------------|
| 1        | D2438F<br>CUT AS PER DWG D2438 REV. C<br>B105681                   | Clamp                  | 9/6/2013<br>Yes<br>9/6/2013          |    | 120.00<br>Each                 | \$1.39             | \$166.80       |
|          |                                                                    |                        |                                      |    |                                | <b>Line Total:</b> | \$166.80       |
| 2        | D3537-1P<br>CUT AS PER DWG D3537 REV. C<br>B105680                 | WEARPAD                | 9/6/2013<br>Yes<br>9/6/2013          |    | 100.00<br>Each                 | \$2.32             | \$232.00       |
|          |                                                                    |                        |                                      |    |                                | <b>Line Total:</b> | \$232.00       |
| 3        | D3537-3P<br>CUT AS PER DWG D3537 REV. C<br>B105934                 | WEARPAD                | 9/6/2013<br>Yes<br>9/6/2013          |    | 100.00<br>Each                 | \$2.63             | \$263.00       |

Note:

8/27/2013



673012 Road 67A, RR#1  
Badjeros Ont.

## Packing Slip

|           |          |
|-----------|----------|
| Date      | S.O. No. |
| 8/14/2013 | 3232     |

| Name / Address                                                             |
|----------------------------------------------------------------------------|
| Dart Aerospace Ltd.<br>1270 Aberdeen Street<br>Hawkesbury, Ont.<br>K6A 1K7 |

|         |  |
|---------|--|
| Ship To |  |
|         |  |

[illegible]

Shipper: \_\_\_\_\_

Trucker: \_\_\_\_\_

Reciever: \_\_\_\_\_

**Any claims Of Shortage's & Damages to be made in 10 days or less from receipt of Goods.. Otherwise we will not be held responsible. Thanks !!**



## MILL TEST CERTIFICATE



SHANXI TAIGANG STEEL CO., LTD

No. 2 JIANGCAOPING, TAIYUAN, SHANXI, P. R. CHINA

TEL: +86-351-3013328 FAX: +86-351-3017816

Http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

|                 |                                       |
|-----------------|---------------------------------------|
| Certificate No. | A88120708A                            |
| Material        | 304/304L                              |
| Surface         | 2B                                    |
| Standard        | ASTM A240/A240M                       |
| Heat Treatment  | Solution 1050-1100 Quenching in water |

Contract No.

Date  
2012/10/11

Inspector's stamp

Shanxi Taigang Steel Co., Ltd.  
Marking

Product

Melting Furnace

EAF+AD

K-ORB-S+VOD

COIL

| No. | Sheet No. | Coil No.      | Batch No. | Quantity | Dimensions (inch) | Edge | Weight (kg) | pg |
|-----|-----------|---------------|-----------|----------|-------------------|------|-------------|----|
| 6   | A1203471  | K120819350110 | 72084823  | 1        | 160A*18"          | 1111 | 10174       |    |
| 7   | A1203357  | F120851050V20 | 82082205  | 1        | 146A*60"          | 1111 | 9010        |    |
| 8   | A1203357  | F120851050V20 | 82082204  | 1        | 146A*60"          | 1111 | 9229        |    |
| 9   | A1203476  | K120817020V10 | 72082238  | 1        | 106A*45"          | 1111 | 9022        |    |
| 10  | A1203357  | F120850390V20 | 82091322  | 1        | 116A*60"          | 1111 | 8236        |    |

Chemical Composition %

| Heat No. | C     | Si   | Mn   | P     | S     | Cr   | Ni  | Cu | N    | Mo | Ti | Nb |
|----------|-------|------|------|-------|-------|------|-----|----|------|----|----|----|
| A1203471 | 0.022 | 0.36 | 1.61 | 0.036 | 0.001 | 18.1 | 8.0 |    | 0.05 |    |    |    |
| A1203357 | 0.026 | 0.43 | 1.35 | 0.035 | 0.001 | 18.3 | 8.0 |    | 0.05 |    |    |    |
| A1203357 | 0.026 | 0.43 | 1.55 | 0.036 | 0.001 | 18.3 | 8.0 |    | 0.04 |    |    |    |
| A1203476 | 0.019 | 0.43 | 1.54 | 0.038 | 0.001 | 18.1 | 8.0 |    | 0.04 |    |    |    |
| A1203357 | 0.026 | 0.43 | 1.55 | 0.036 | 0.001 | 18.3 | 8.0 |    | 0.05 |    |    |    |

| Test       | No. | Tensile | Proof Stress | Proof Stress | Yield Stress | AS0 (%) | A (%) | Elongation | Hardness  |
|------------|-----|---------|--------------|--------------|--------------|---------|-------|------------|-----------|
|            |     | MPa     | MPa          | MPa          | MPa          |         |       |            | HBS       |
|            |     |         |              |              |              |         |       |            | HV        |
| 72084823-T | 655 | 281     |              |              |              |         |       |            | 85.0 85.0 |
| 82091209-T | 605 | 282     |              |              |              |         |       |            | 83.0 83.5 |
| 82082204-T | 615 | 282     |              |              |              |         |       |            | 83.5 83.0 |
| 72082238-T | 690 | 305     |              |              |              |         |       |            | 89.0 88.5 |
| 82091322-T | 645 | 293     |              |              |              |         |       |            | 84.0 83.0 |

Notes:

- The quality management system is in conformity with ISO9001:2008 standard.
- The environmental management system is in conformity with ISO14001:2004 standard.
- No weld repair: Free of rework.
- Surface and dimensions control: O.K.
- Intergranular corrosion test: NO CRACK
- Se hereby certify that the material described above has been detected and has no radiation contamination.



Work Inspector:

Place: Taiyuan

Page: 2 of 2

Mar 15 2014